

Date: Wednesday, 11/02/2009 11:47:17 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HAT BIN 206 A/B
 Job Number : 45747
 Estimate Number : 13592
 P.O. Number :
 This Issue : 11/02/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : 11/02/2009 Type : R&D THERMOFORMING
 Previous Run : 44462
 Part Number : D38241
 Drawing Number : D38241 REV A UNDER R
 Project Number : IN0002
 Drawing Revision : REV A UNDER RW
 Material : MKYD6185S125P362015
 Due Date : 18/02/2009 Qty: 2 Um: Each
 Written By :
 Checked & Approved By : JUD 09.02.11
 Comment : Est. A New Issue 08/09/17 DL

Additional Product

Job Number:



09.02.11

Seq. #:

Machine Or Operation:

Description :

1.0

MKYD6185S125P362015

6185 KYDEX .125"



Comment: Qty.: 11.3747 sf(s)/Unit Total: 22.7493 sf(s)
 6185 Kydex .125" M 110426

2.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Machine set up

BB 09/02/11

3.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

BB 09/02/11

X2

4.0

THERMOFORMING

THERMOFORMING MACHINE



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3824-1 and folio (FTA 9405 Prototype) using tool DT 9405

Dwg. Rev. A

Folio Rev. C

BB 09/02/11

X2

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

BB 09/02/11 P10 X1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/02/17	4	CONSUMED R+D.						

NOTE: Date & initial all entries

Date: Wednesday, 11/02/2009 11:47:17 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HAT BIN 206 A/B

Job Number: 45747

Part Number: D38241

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Dr 09/02/11

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

Dr 09/02/11

X1

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Dr 09/06/15

(H)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

mf

w/o D206-781-171 KIV

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/16

Job Completion



POSITIVE RECALL

EFFECTIVE

01.06.15

AUTH

u

RELEASED

mf

DATE

09/06/11

mf 09-06-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 45747
Description: D3824-1 206 Hot bin. U/Review		Part Number: D3824-1
Inspection Dwg: D3824 Rev: A Per 0.125" mat'l		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: JOS 02-23 **Date:** _____

TRIMMING SECTION

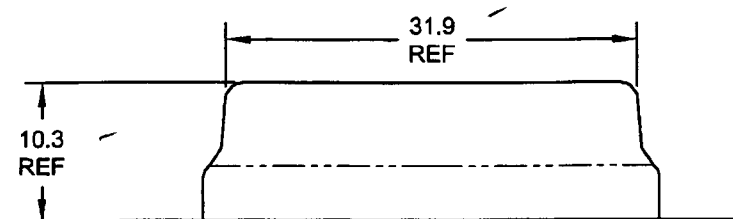
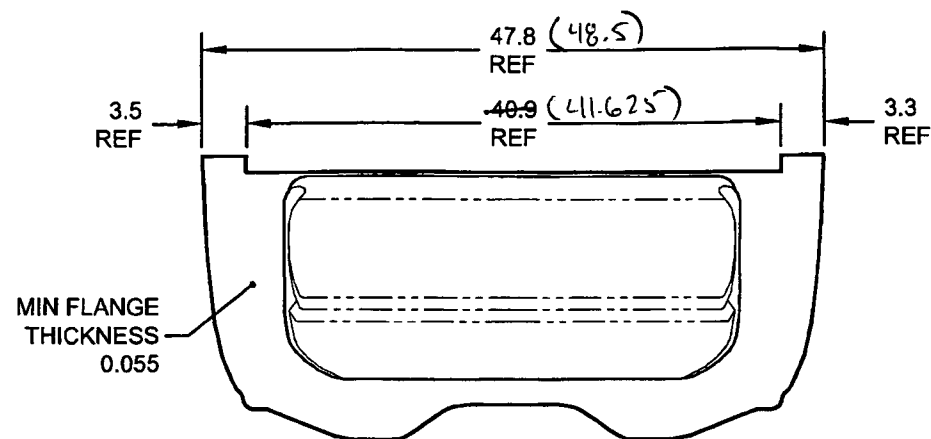
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.430	+0.05/-0.00					
0.055 (Flange)	min mat. thick	0.120	✓			with 0.125" mat'l
0.030 (drawn)	min.					
47.8 (Ref)		48.5			Tape	
40.9 (Ref)		41.625			Tape	
34.1 (Ref)		34.1	✓		Tape	from center of Rad.
1.3 (Ref)		1.29	✓		Vern.	
15.5 (Ref)		15.5	✓		Tape	from center of Rad
2.1 (Ref)		2.1	✓		Tape	Top to center of Rad.
3.5 (Ref)		3.5	✓		Tape	
3.3 (Ref)		3.375	✓		Tape	
10.3 (Ref)		10.3125	✓		Tape	

Measured by: [Signature] **Date:** 09-02-23

Audited by: [Signature] **Date:** 09-06-11

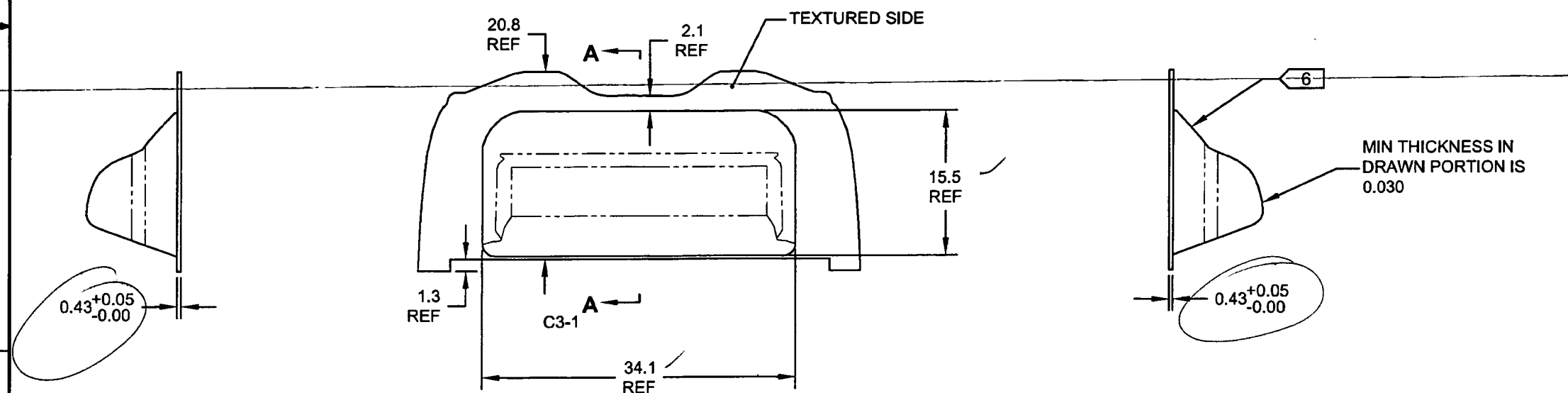
Prototype Approval: N/A **Date:** N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



SECTION A-A
B6-1
SCALE 2X

SHOP COPY
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WORK ORDER
NO. HS747



D3824-1 HAT BIN
(BELL 206 A/B)

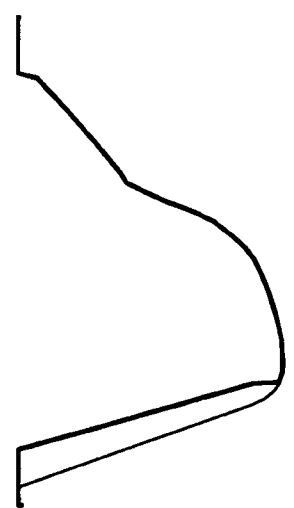
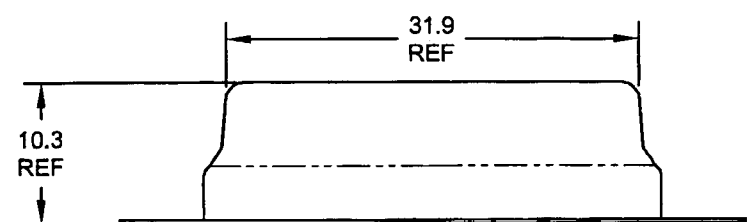
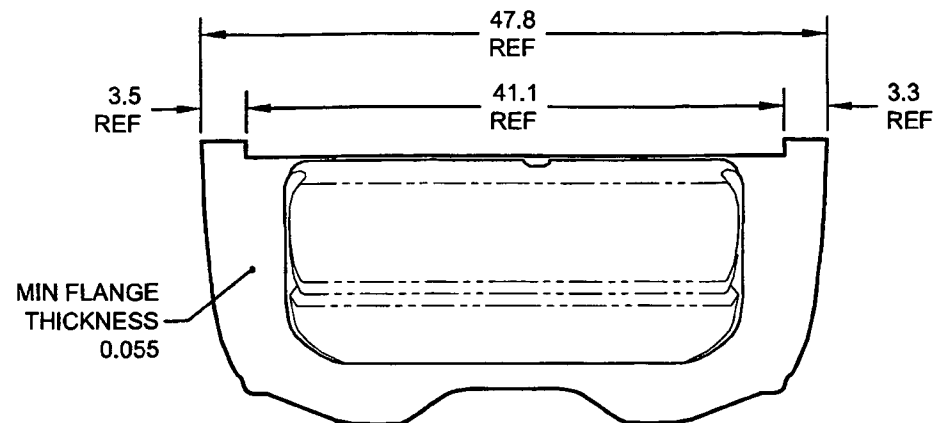
NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
(REF DART SPEC MKYD6185S.080-P3-62015)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3824-1" USING VIBRATING STYLUS
- 7) WEIGHT: 3.7 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9405 PER DART QSI 022. TRIM PER MOLD

UNDER REVIEW
LWG NAT'L TO 0.125
PH 09.02.05

RELEASED
09/01/12

A	NEW ISSUE	PH	08.10.01
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3824	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		HAT BIN (BELL 206 A/B)	NTS
DATE	08.10.01	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

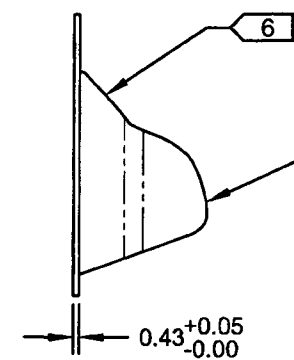
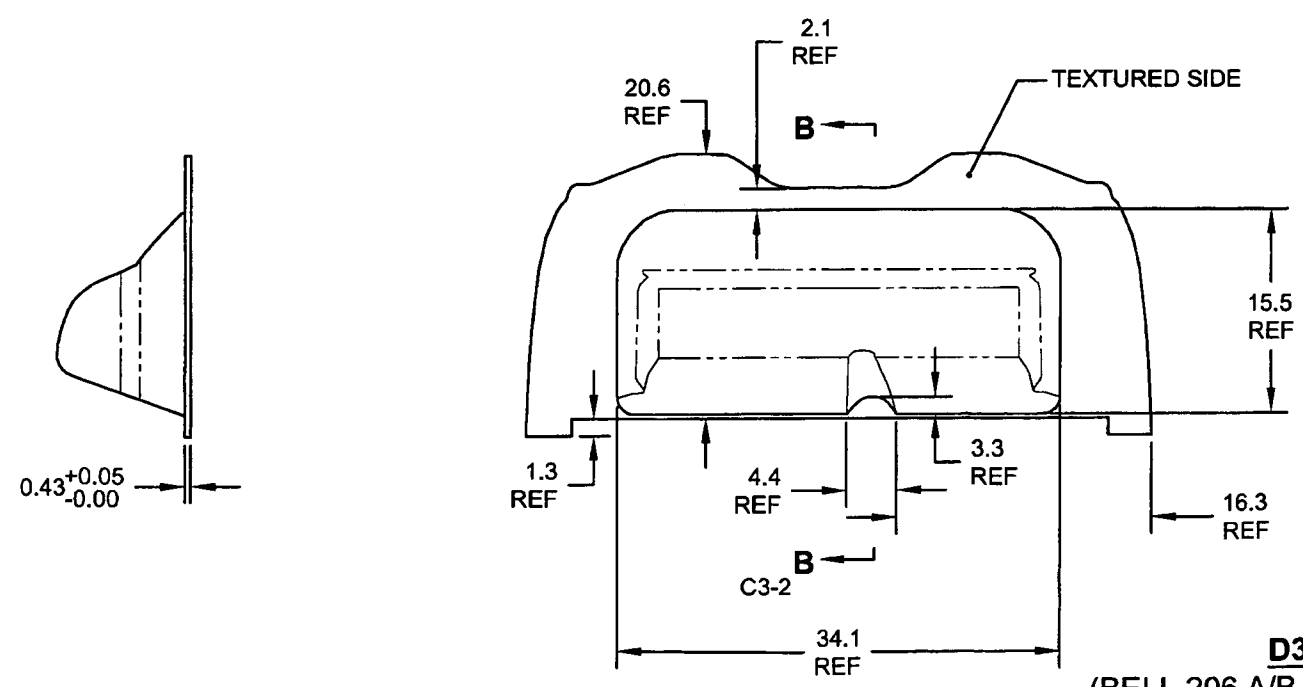


SECTION B-B
SCALE 2X

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WITHOUT NOTICE
WORK ORDER
NO. 4574

UNDER REVIEW
CHG MAT'L TO 0.125"
09.02.05

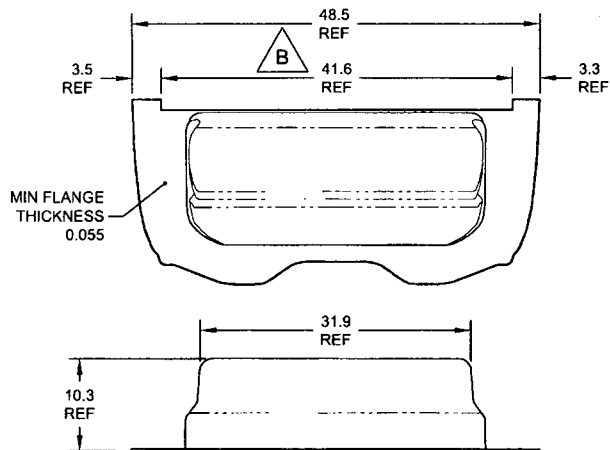
RELEASED
09/01/12



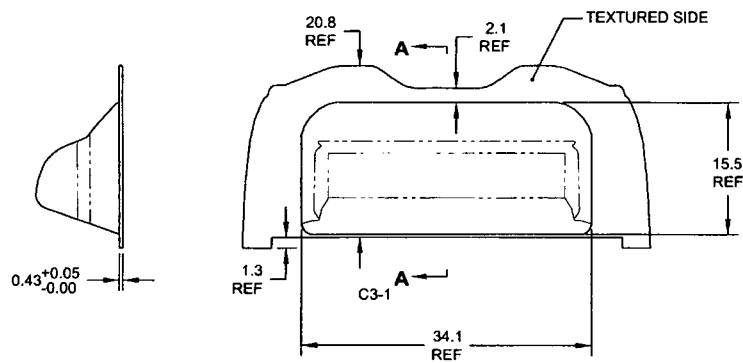
D3824-3 HAT BIN
(BELL 206 A/B, LITTER KIT COMPATIBLE)

- NOTES:**
- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (REF DART SPEC MKYD6185S.080-P3-62015)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3824-3" USING VIBRATING STYLUS
 - 7) WEIGHT: 3.7 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9448 PER DART QSI 022. TRIM PER MOLD

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3824	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		HAT BIN (BELL 206 A/B)	NTS
DATE	08.10.01	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



SECTION A-A
SCALE 2X



D3824-1 HAT BIN
(BELL 206 A/B)

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 5.6 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9405 PER DART QSI 022. TRIM PER MOLD



PART NUMBER	DESCRIPTION
D3824-1KIV	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3824-1KGY	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

C	ADD STEEL GRAY COLOUR OPTION, ADD IVORY P/N'S D3824-1KIV, D3824-3KIV AND ADD STEEL GRAY P/N'S D3824-1KGY, D3824-3KGY (ZN A5-1, A5-2)	PH	09.05.05
B	0.125 THICK WAS 0.080 (ZN A7-1, A7-2) REASON: TO IMPROVE DURABILITY; MODIFY WIDTH TO ALLOW FOR BETTER FIT WITH A/C (ZN D6-1, D6-2)	PH	09.02.19
A	NEW ISSUE	PH	08.10.01
REV.	DESCRIPTION	BY	DATE
DESIGN	PA		
DRAWN	PA		
CHECKED	PA		
MFG. APPR.	PA		
APPROVED	PA		
DE APPR.	PA		
DATE	09.05.05		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3824 REV. C
SHEET 1 OF 2

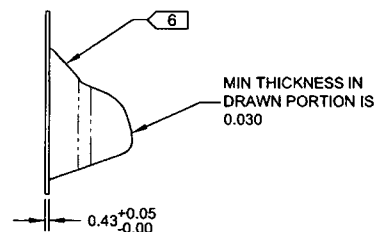
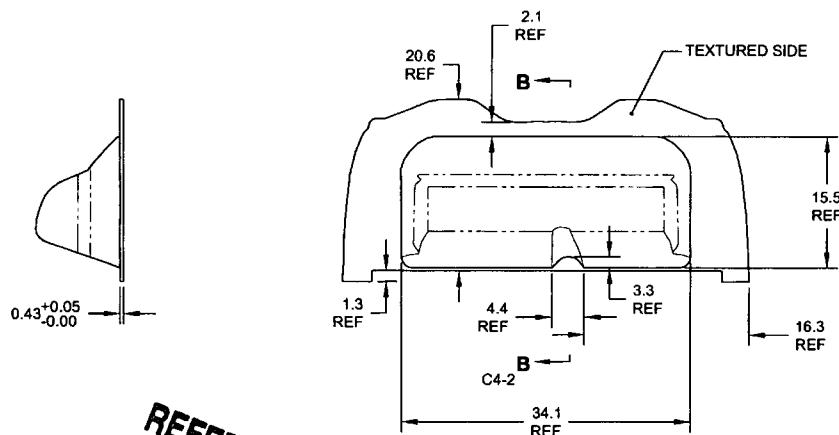
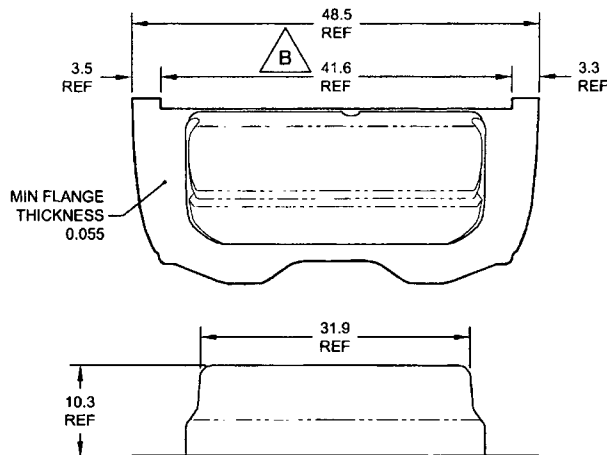
TITLE HAT BIN (BELL 206 A/B) SCALE NTS

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RELEASED
9/5/05

W6 45747

8 7 6 5 4 3 2 1



REFERENCE ONLY

D3824-3 HAT BIN
(BELL 206 A/B, LITTER KIT COMPATIBLE)

- NOTES:**
- 1) MATERIAL: SEE TABLE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
 - 7) WEIGHT: 5.6 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9448 PER DART QSI 022. TRIM PER MOLD

C
C

PART NUMBER	DESCRIPTION
D3824-3KIV	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3824-3KGY	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	DART AEROSPACE LTD
DRAWN	HAWKESBURY, ONTARIO, CANADA
CHECKED	DRAWING NO. REV. C
MFG. APPR.	D3824 SHEET 2 OF 2
APPROVED	TITLE SCALE
DE APPR.	HAT BIN (BELL 206 A/B) NTS
DATE	09.05.05
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45747

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9/10/12

8 7 6 5 4 3 2 1